

Date: Tuesday, 11/29/2005 3:06:17 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 25019	Part Number	: D2574		
Estimate Number	: 10534	Drawing Number	: D2574 REV D		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 11/29/2005	S.O. No.	: N/A		
Prsh't Rev.	: NC	Drawing Revision	: D		
First Issue	: N/A	Material	: N/A		
Previous Run	: 24840	Due Date	: 1/5/2006	Qty:	8 Um: Each
Written By	<u>SEE COMMENT BELOW</u>				
Checked & Approved By	<u>SEE ABOVE DATE & USER</u>				
Comment	: Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B21817A (1)</u>	<u>B25204</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>25019</u> Double check by: <u>SJ</u>	<u>J.G. 06/01/16</u> <u>MS 06/01/16</u>
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. N/A	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	

Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

-MS 06/01/16
-J.G. 06/01/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25019

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

- M8 06/01/18
- J.G.



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

BG

06.01.24

8

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-02-09

8

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/02/19

8

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

C 06/02/20

⑧

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST480

C 06/02/20

⑧

8

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/02/21

(8)

DD 06/02/21

⑧

Job Completion



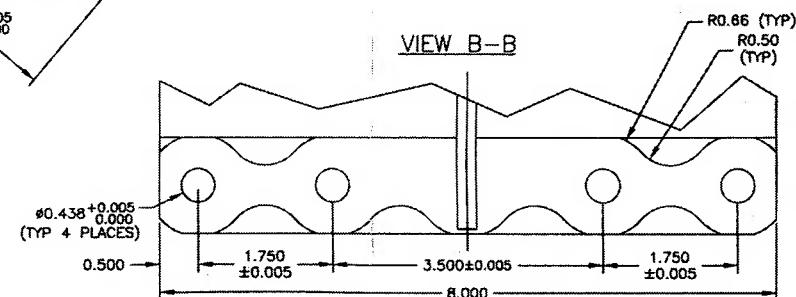
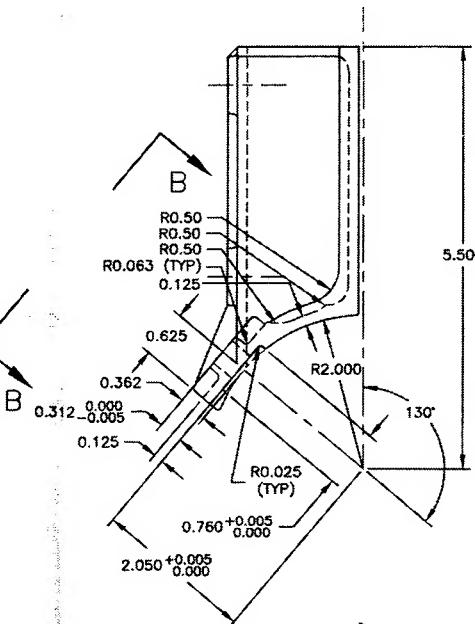
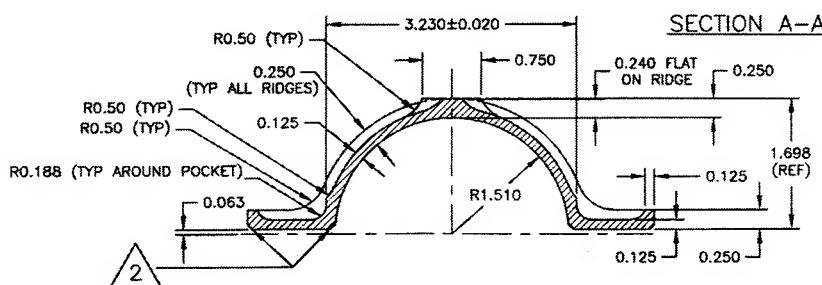
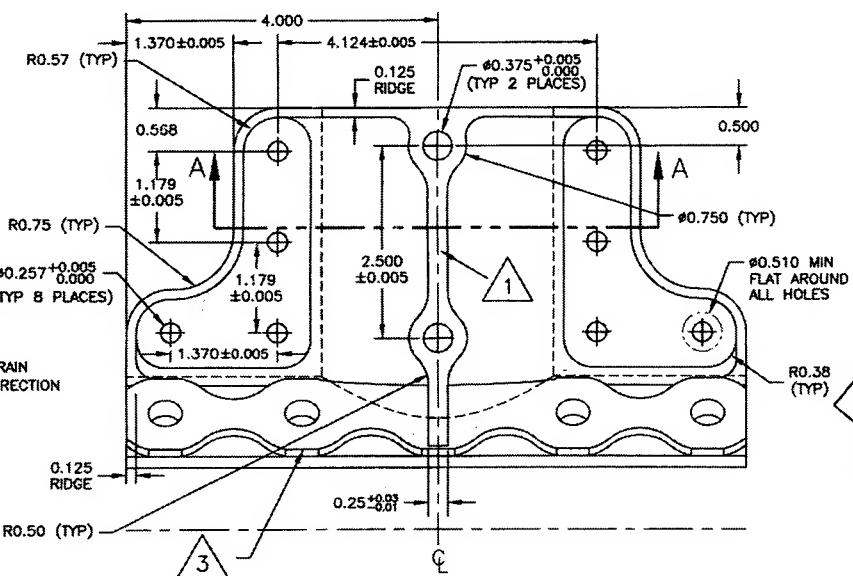
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
02-09-25 97



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND

D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2574 SHEET 1 OF 1
DATE	TITLE	SCALE 02.09.06 INNER AFT SADDLE 2:3

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DART AEROSPACE LTD.

DART AEROSPACE LTD

Work Order:

25019

Description: Saddle, Aft Inboard

Part Number:

D2574

Inspection Dwg: D2574 Rev. E

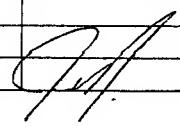
Page 1 of 1

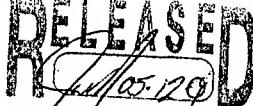
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.497		
D	1.745	1.755		1.750	1.750	1.750	1.748		
E	7.990	8.010		8.002	8.003	8.004	8.004		
F	0.490	0.510		.505	.503	.506	.500		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.502	.504	.505	0.499		
J	1.174	1.184		1.180	1.180	1.180	1.179		
K	0.558	0.578		.571	.574	.574	0.569		
L	1.174	1.184		1.180	1.180	1.180	1.179		
M	1.365	1.375		1.370	1.370	1.369	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.497		
O	4.119	4.129		4.121	4.124	4.124	4.120		
P	0.115	0.135		.126	.125	.127	0.128		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.250	.250	.250	0.251		
S	0.115	0.135		.126	.125	.125	0.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.234	3.232	3.231		
V	0.230	0.250		.243	.241	.240	0.241		
W	0.115	0.135		.125	.125	.125	0.125		
X	0.307	0.312		.308	.311	.311	.309		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.365	.360	.362	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.629	.629	0.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.248	.246	0.247		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.135	.135	.135	0.135		
AG	0.240	0.280		.272	.270	.270	0.271		
AH	0.240	0.260		.252	.248	.250	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		.03	.03	.03	.03		
Accept/Reject									

Measured by: M8 /
 Date: 06/01/18

Audited by: J.G
 Date: 06/01/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

 05/12/18

DART AEROSPACE LTD

Work Order:

25019

Description: Saddle, Aft Inboard

Part Number:

D2574

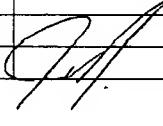
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D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.004	8.003		
F	0.490	0.510		0.500	.499	.499	.502		
G	0.257	0.262	DT8683	0.260	✓	✓	✓		
H	0.375	0.380	DT8684	0.377	✓	✓	✓		
I	0.490	0.510		0.4985	.501	.501	.500		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		0.570	.568	.572	.575		
L	1.174	1.184		1.176	1.180	1.180	1.180		
M	1.365	1.375		1.360	1.370	1.370	1.370		
N	2.495	2.505		2.497	2.501	2.500	2.500		
O	4.119	4.129		4.119	4.121	4.122	4.123		
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Q	0.115	0.135		0.134	.135	.135	.135		
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W	0.115	0.135		0.122	.125	.125	.125		
X	0.307	0.312		0.312	.310	.310	.310		
Y	0.760	0.765		0.760	.762	.762	.762		
Z	0.352	0.372		0.356	.356	.359	.356		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.622	.626	.623	.621		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.246	.248	.246	.247		
AE	1.500	1.520		1.510	1.511	1.511	1.511		
AF	0.115	0.135		0.130	.135	.135	.135		
AG	0.240	0.280		0.265	.269	.270	.270		
AH	0.240	0.260		0.246	.251	.251	.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	.03	.03	.03		
Accept/Reject									

Measured by: /MS
Date: 06/01/21Audited by: J.G.
Date: 06/01/21

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RELEASED
05/12/20